

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-161 Date Opened: 28 September 2017 Title: Fabrication

Aircraft OEM: Airbus Aircraft Model: AS350 Product Type: Bike Rack Product Model: Bushing Quantity: 200

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

CB
N/A
CB
N/A
N/A
QC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

QC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100220	0	Sliding Frame Fabrication	CB

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

200
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
QC
N/A
N/A
QC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

CB
N/A
N/A

Work performed by:

Print: J. CLARKE

ICC / Dual Inspection performed by:

Print:

Work Order closed by:

Print: J. CLARKE

Sign:

Sign:

Sign:

SCA: AD02

SCA:

SCA: AD02

Date: 03 OCT 2017

Date:

Date: 01 NOV 2017

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-161

Batch Quantity: 200

Complete
(initial or SCA #)

Date Open: 28 Sept. 2017

Part Number: 100220-03

1. Cut stock material:

JK.

- Enter material PO:
- Cut stock to length
- Tag in-progress parts and place on in-progress shelf in machine shop.

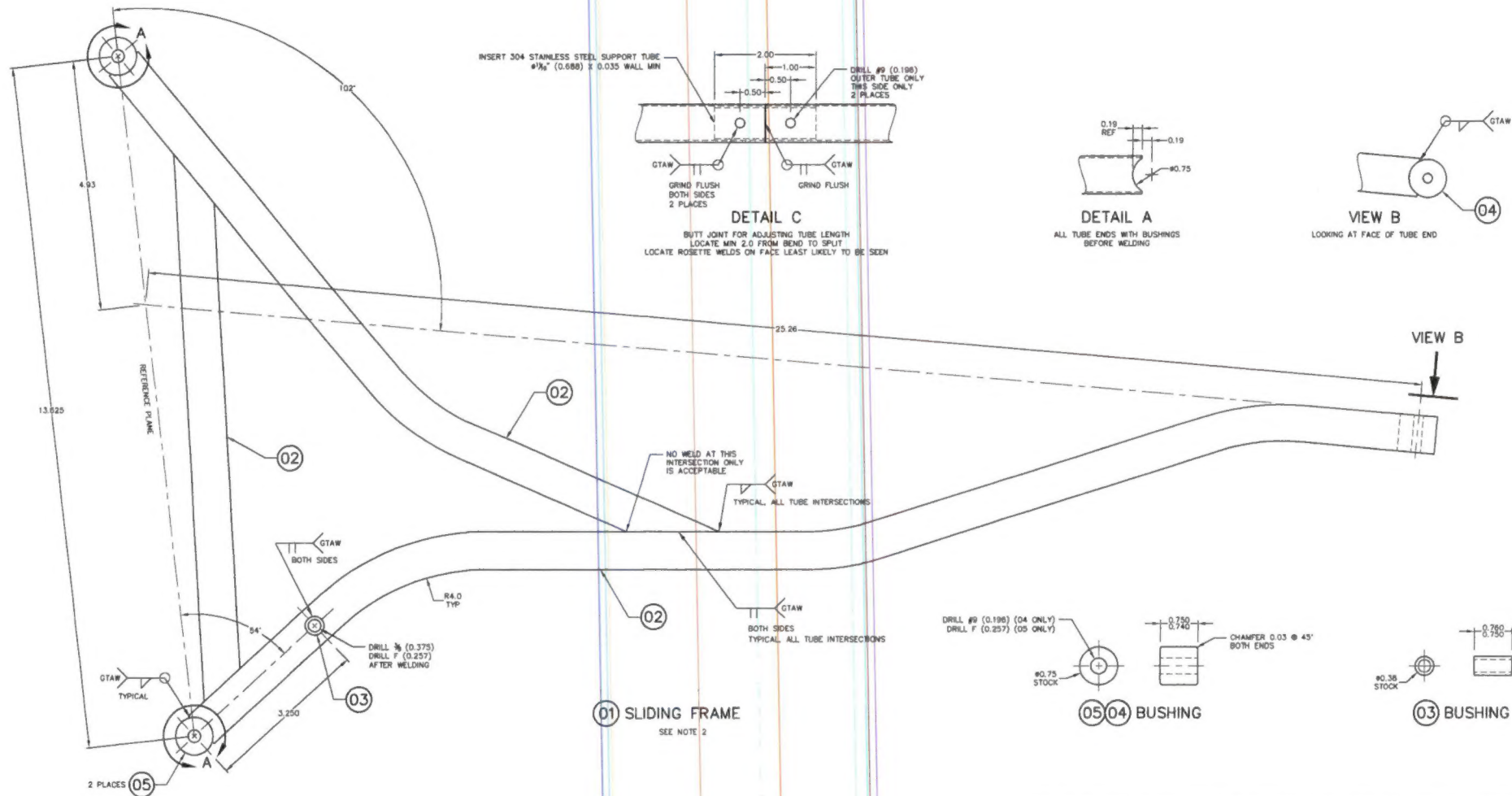
PO: 17050

2. Buff one end

JK.

- Tag completed parts

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. USE FULL SCALE DRAWING AS TEMPLATE. CRITICAL DIMENSIONS SHOWN. INDIVIDUAL TUBE LOCATIONS AND ANGLES MAY VARY UP TO 1/16" (0.06) SO LONG AS CRITICAL DIMENSIONS ARE MAINTAINED. ENSURE BATCHED PARTS ARE IDENTICAL TO EACH OTHER. BUTT JOINTS MAY BE USED TO ACHIEVE REQUIRED LENGTHS, SEE DETAIL C.
3. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER60BL OR EQUIVALENT.
4. FINISH - STAINLESS STEEL PARTS: FRAME MAY BE POLISHED USING SCOTCH BRITE WITH NO FURTHER COATING. ALTERNATE: THOROUGHLY DEGRADE AND POWDER COAT. ALTERNATE: THOROUGHLY DEGRADE, EPOXY PRIME AND POLYURETHANE PAINT.

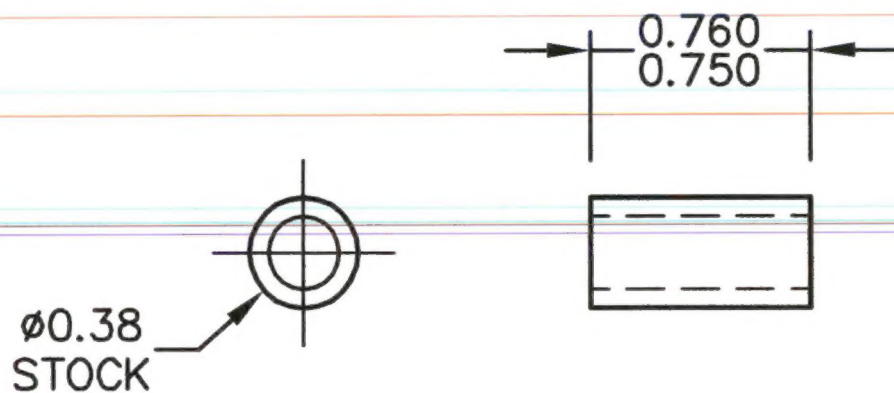
2	100220-05	05	BUSHING (0.75 X 0.257 ID)	304 STAINLESS STEEL	ASTM A479	#0.75 ROD
1	100220-04	04	BUSHING (0.75 X 0.198 ID)	304 STAINLESS STEEL	ASTM A479	#0.75 R/OOD
1	100220-03	03	BUSHING (0.375 X 0.245 ID)	304 STAINLESS STEEL	ASTM A269	#0.375 X 0.065 TUBE
A/R			02 TUBE	304 STAINLESS STEEL	ASTM A354	0.75 X 0.035 SQW TUBE
01	100220-01	01	SLIDING FRAME			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
APPROVALS			DATE			
DRAWN: JEFF CLARKE			13 JUNE 2016			
CHECKED: JASON REKVE			13 JUNE 2016			
UNLESS OTHERWISE SPECIFIED			DIMENSIONS ARE IN INCHES.			
TOLERANCES ON:						
DECIMALS			ANGLES			
X.XXX			±1/2°			
X.XX			±0.03			
X.X			±0.1			
SCALE 1 : 1			DWG. SIZE	THW. NO.	REV.	
SHEET 1 OF 1			A1	100220	0	



AERO DESIGN LTD.

9808A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.3216 www.aerodesign.co

AIRBUS HELICOPTERS AS350/AS355/EC130
BICYCLE RACK INSTALLATION
SLIDING FRAME FABRICATION



(03) BUSHING

STEEL

ASTM A479

$\phi 0.75$ ROD

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-160 Date Opened: 27 September 2017 Title: AssemblyAircraft OEM: Bell Aircraft Model: 429 Product Type: Cargo Basket Product Model: RH Post S/N 81 Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95950	0	Basket Assembly	JC
95917	1	Lid Checker Plate	JC
95965	0	Fwd Sheet	JC
95916	1	Filler Sheet	JC
95927	1	Placard	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
36280	3	Lid Brace Assembly	JC

Traveller

Install checker plate on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR

Work performed by:

Print: C. Brander/J. RekveSign: J. Rekve

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: J. Clarke

Work Order closed by:

Print: J. ClarkeSign: J. Clarke

Approved Manufacturing Facility 73-04

Form 20.D.03

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

SCA: AD01Date: 02-Oct-17SCA: AD02Date: 02-Oct-17SCA: AD02Date: 10-Oct-17

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Aircraft:

All

Model: All

Description:

Hinge

Supplier:

GKN Aerospace Bandy Machining

Color:

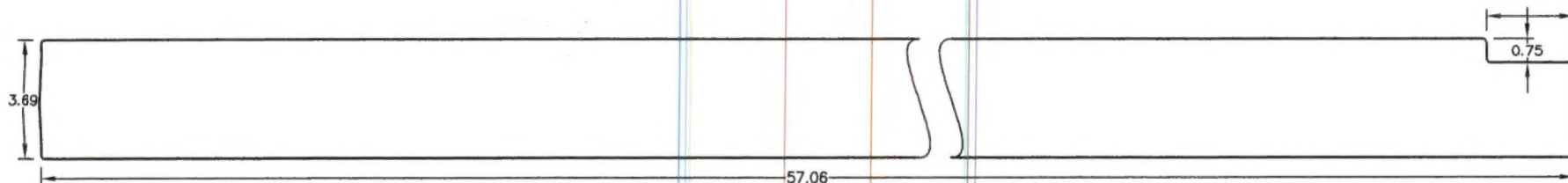
N/A

WO#:

N/A

PO# 17017

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



① FORWARD FILLER SHEET




② AFT FILLER SHEET

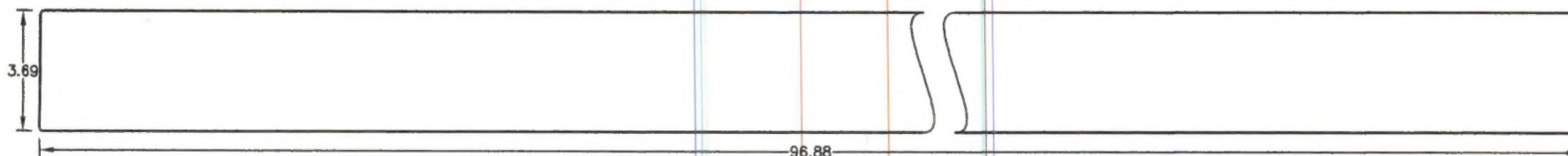
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95916-02	02	AFT FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
1	95916-01	01	FORWARD FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.


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	CHECKED: E. BURGON		10 NOV 2012			POWELL RIVER, BC, CANADA, V8A 0G3				
						TEL: 604.483.2376 www.aerodesign.ca				
NOTICE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				BELL 429 QUICK RELEASE CARGO BASKET FILLER SHEET					
	DECIMALS		ANGLES							
	X.XXX ±0.010		±1/2"							
	X.XX ±0.03									
	X.X ±0.1				SCALE 1 : 4		DWG. SIZE	DWG. NO.	REV.	
					SHEET 1 OF 2		LGL	95916	1	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



03 FILLER SHEET

1	95916-03	01	FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY LIST OF MATERIALS						

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1					
	BELL 429 QUICK RELEASE CARGO BASKET FILLER SHEET					
	SCALE 1 : 4 SHEET 2 OF 2					
		DWG. SIZE	DWG. NO.	REV.		
		LGL	95916	1		

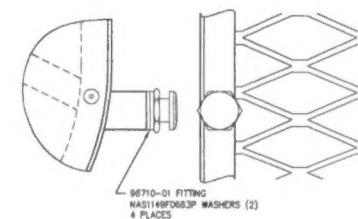
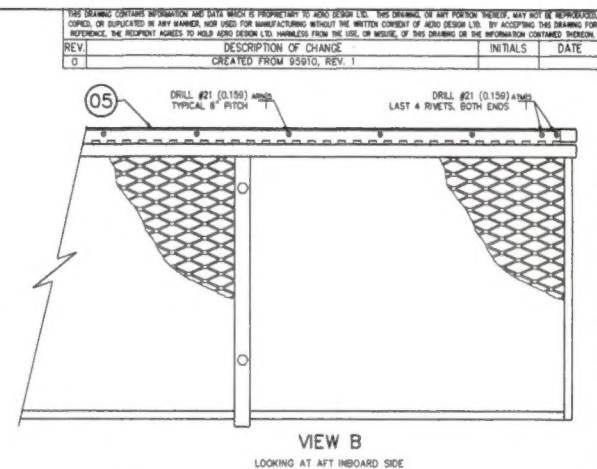
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0377	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-160	
6. Item	7. Description Cargo Basket	8. Part Number 95950-01-01	9. Qty. 1	10. Serial/Batch No. 95911-06	11. Status/Work New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 02 Oct 2017		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

HANGAR ONE

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. INSTALL RIVETS USING EDGE DISTANCE AND PITCH AS OUTLINED IN AC43.13-1B, PAR 4-5B, FIG 4-5 AND FIG 4-6.



SCALE 1 : 1
LOOKING AT FORWARD LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
REAR ATTACHMENTS SIMILAR

A/R/A/R	QTY	PART NO	ITEM	DESCRIPTION	MATERIAL
A/R/A/R	1	---	---	SEALONE SEALANT (CLEAR)	COMMERCIAL
A/R/A/R	1	C53204	---	SEALING COMPOUND	AMS-5-6802C 2T B7C
B	8	NAS114F0683P	---	WASHER	
4	4	86710-01	---	FITTING	ALT: ANCR4 4008B-14
A/R/A/R	1	CR313-4-02	---	CHERRY RIVET	ALT: HR313-4-02
B	6	CR3523-5-02	---	CHERRY RIVET	ALT: HR3523-5-02
A/R/A/R	1	CR3213-5-02	---	CHERRY RIVET	ALT: HR3213-5-02
A/R/A/R	1	95916-03	---	13 FLUOR SHEET	ALTERNATE TO 09/10
4	4	40085-12	---	BUMPER	ARGUS INDUSTRIES
1	1	95917-02	11	LM LD CHECKER PLATE	
1	1	95917-01	11	RH LD CHECKER PLATE	
1	1	95916-02	10	AFT FILLER SHEET	
1	1	95916-01	09	FORWARD FILLER SHEET	
1	1	95965-02	06	LH FORWARD SHEET	
1	1	95965-01	06	RH FORWARD SHEET	
1	1	95927-04	07	LH PLACARD	
1	1	95927-03	07	RH PLACARD	
1	1	94255-06	---	HANDLE BAR INSTALLATION	
1	1	MS20001P4	05	PIANO HINGE	95" LONG
1	1	94240-01	14	LD BRACE INSTALLATION	
1	1	95912-02	03	LH LD ASSEMBLY	
1	1	95912-01	03	RH LD ASSEMBLY	
1	1	95951-01-02	02	LH BASKET BODY ASSEMBLY	
1	1	95951-01-01	02	RH BASKET BODY ASSEMBLY	
1	1	95950-01-02	01	LH CARGO BASKET ASSEMBLY	
1	1	95950-01-01	01	RH CARGO BASKET ASSEMBLY	
-02-01	---	---	---	---	---
QTY	QTY	PART NO	ITEM	LIST OF MATERIALS	MATERIAL



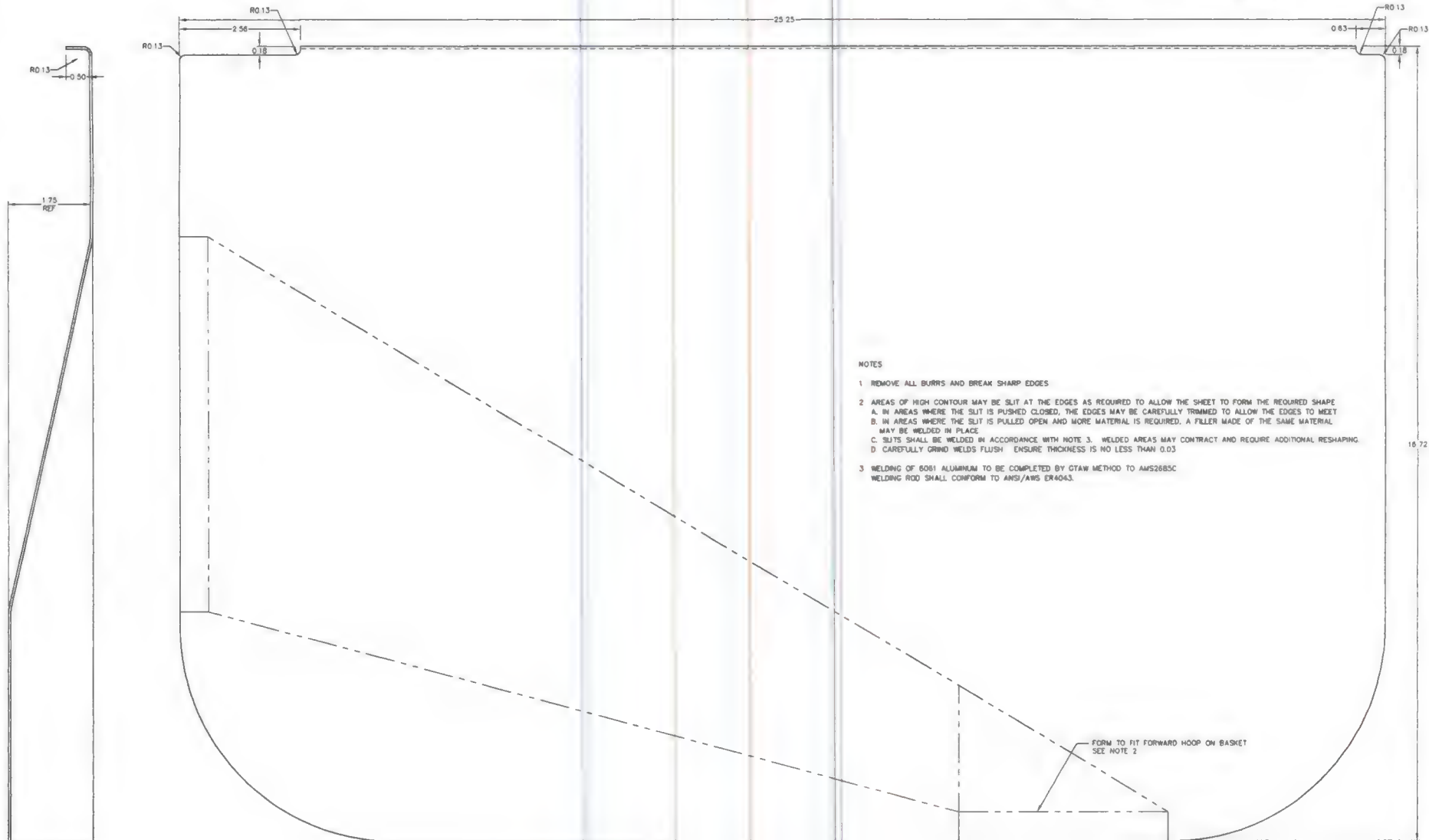
AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.3370 www.aerodesign.ca

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	95950	0



BASIC CODE REF: NAS 323		DASH NO. FOR DIAMETER M=MF: HEAD NEAR SIDE F=MF: HEAD FAR SIDE		APPROVALS		DATE	
C=COUNTERSINK D=DIMPLE DIGIT# of DIMPLES TO BE SHAPED		DASH NO. FOR LENGTH		DRAWN: JEFF CLARK CHECKED: JASON REKIVE		20 FEB 1941	
BASIC CODES: B = MIS2042AD RF = MIS2042AD ARM = CR2131 ATN = CR3523		<div><div><div><div></div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div><div></div></div><div></div></div></div> <div>INSTALL NEW RIVET</div> <div><div><div><div></div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div><div></div></div><div></div></div></div> <div>REMOVE/REPLACE RIVET</div> <div><div><div><div></div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div><div></div></div><div></div></div></div> <div>EXISTING RIVET</div>		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES XXX ±0.010 ±1/2" XX ±0.03 X ±0.1			

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. AREAS OF HIGH CONTOUR MAY BE SLIT AT THE EDGES AS REQUIRED TO ALLOW THE SHEET TO FORM THE REQUIRED SHAPE
 - A. IN AREAS WHERE THE SLIT IS PUSHED CLOSED, THE EDGES MAY BE CAREFULLY TRIMMED TO ALLOW THE EDGES TO MEET
 - B. IN AREAS WHERE THE SLIT IS PULLED OPEN AND MORE MATERIAL IS REQUIRED, A FILLER MADE OF THE SAME MATERIAL MAY BE WELDED IN PLACE.
 - C. SLITS SHALL BE WELDED IN ACCORDANCE WITH NOTE 3. WELDED AREAS MAY CONTRACT AND REQUIRE ADDITIONAL RESHAPING.
 - D. CAREFULLY GRIND WELDS FLUSH. ENSURE THICKNESS IS NO LESS THAN 0.03
3. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AWS2685C WELDING ROD SHALL CONFORM TO AWS/ANS ER4043.

FORM TO FIT FORWARD HOOP ON BASKET
SEE NOTE 2

01 FORWARD SHEET
RH. SHOWN, LH. OPPOSITE

QTY	QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
		95965-02	01	FORWARD SHEET (LEFT HAND)	6061 ALUMINUM	QQ-A-250/31	0.050 SHEET
		95965-01	01	FORWARD SHEET (RIGHT HAND)	6061 ALUMINUM	QQ-A-250/31	0.050 SHEET

LIST OF MATERIALS

APPROVALS		DATE	
DRAWN	JEFF CLARKE	10 APR 2014	
CHECKED	JASON REKVE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			
DECIMALS	ANGLES		
X.XXX	±0.010	±1/2°	
X.XX	±0.03		
X.X	±0.1		
SCALE 1:1		DWG. SIZE	DWG. NO.
SHEET 1 OF 1		A1	95965
			0



AERO DESIGN LTD.

9088A MALASPINA ROAD
POWELL RIVER, B.C. CANADA V8A 0G3
TEL. 604.483.3370 www.aerodesign.ca

BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
FORWARD SHEET

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; ADDRESS, LOGO AND S/N UPDATED	BJC	11/03/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 429" - 0.080 HIGH
 "S/N 959YY-XX" - 0.080 HIGH - (SEE NOTES 2-5)
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH
 "www.aerodesign.ca" - 0.080 HIGH
- ITEM 01: RH BASKET FOR A/C S/N THRU 57080, S/N TO READ:
 "S/N 95901-XX" - 0.080 HIGH
- ITEM 02: LH BASKET FOR A/C S/N THRU 57080, S/N TO READ:
 "S/N 95902-XX" - 0.080 HIGH
- ITEM 03: RH BASKET FOR A/C S/N 57081 AND SUB, S/N TO READ:
 "S/N 95911-XX" - 0.080 HIGH
- ITEM 04: LH BASKET FOR A/C S/N 57081 AND SUB, S/N TO READ:
 "S/N 95912-XX" - 0.080 HIGH


DRILL #30 (0.129)
4 PLACES



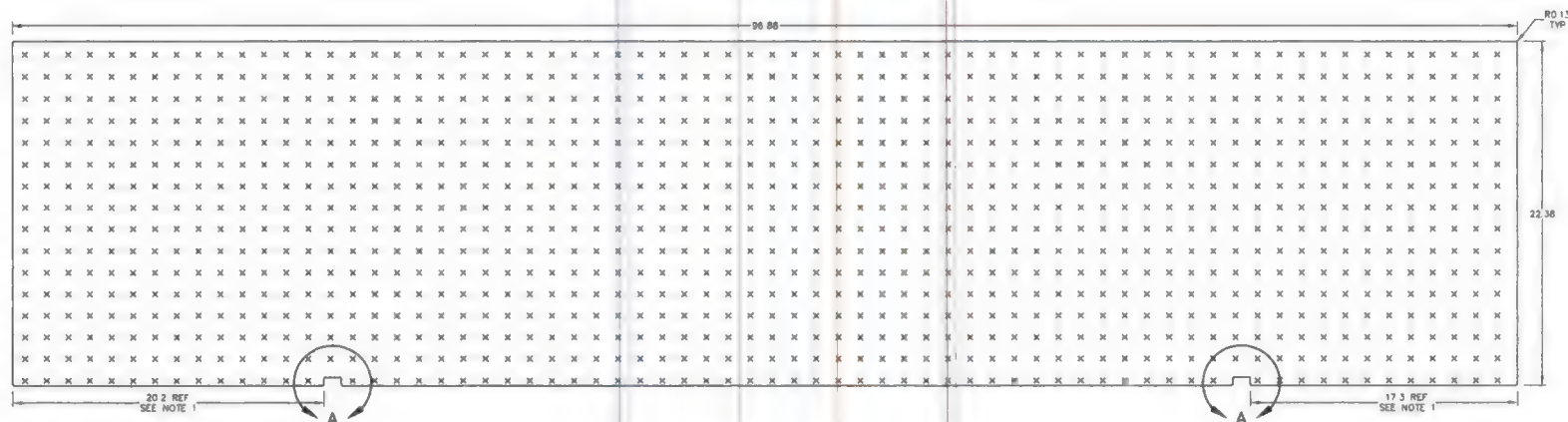
01 02 03 04 PLACARD

1	95927-04	04	LH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-03	03	RH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-02	02	LH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-01	01	RH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

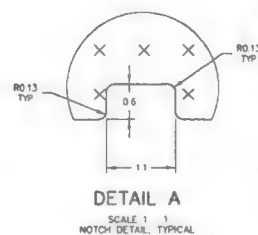
QTY	LIST OF MATERIALS
-----	-------------------

APPROVALS		DATE			AERO DESIGN LTD.				
DRAWN: JEFF CLARKE		11 SEPT 2012			9888A MALASPINA ROAD				
CHECKED: E. BURGOIN		10 NOV 2012			POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				BELL 429					
				QUICK RELEASE CARGO BASKET					
				PLACARD					
				SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.	
				SHEET 1 OF 1		A1	95927	1	

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PART THEREOF MAY NOT BE REPRODUCED, COPIED, OR EMULATED BY ANY MEANS, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK	BJC	10/04/2014




01 LID CHECKER PLATE
RIGHT HAND SHOWN, LEFT HAND OPPOSITE



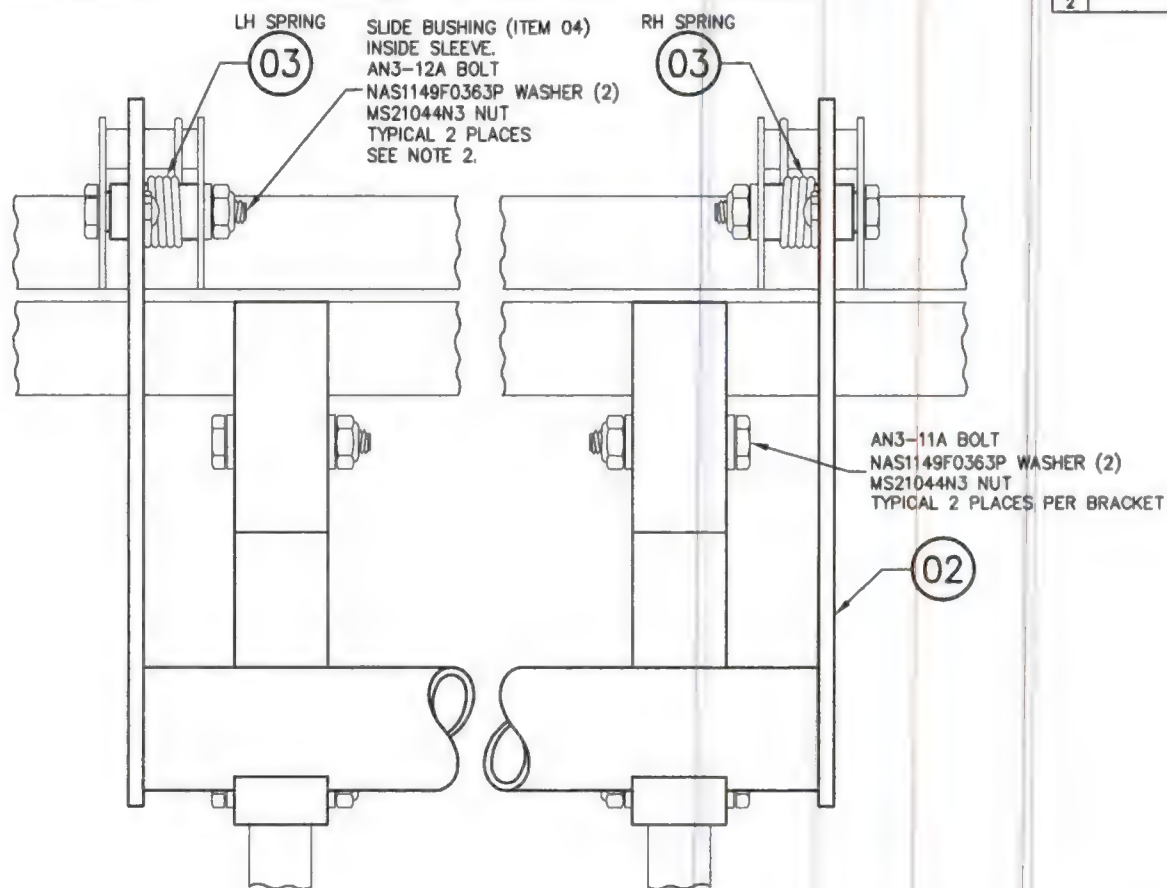
NOTES

1. LOCATION OF NOTCHES TO FIT LID ASSEMBLY 95912-01.
2. REMOVE ALL BURRS AND BREAK SHARP EDGES.

1	95917-02	01	LH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	0.063" C-102 CHECKER								
1	95917-01	01	RH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	0.063" C-102 CHECKER								
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE								
QTY	LIST OF MATERIALS													
<table><tr><td>APPROVALS</td><td>DATE</td></tr><tr><td>DRAWN: JEFF CLARKE</td><td>09 NOV 2012</td></tr><tr><td>CHECKED: E BURGON</td><td>10 NOV 2012</td></tr></table>				APPROVALS	DATE	DRAWN: JEFF CLARKE	09 NOV 2012	CHECKED: E BURGON	10 NOV 2012	<div>AERO DESIGN LTD. 2005A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604 483 2376 www.aerodesign.ca</div> <div>BELL 429 QUICK RELEASE CARGO BASKET LID CHECKER PLATE FABRICATION</div>				
APPROVALS	DATE													
DRAWN: JEFF CLARKE	09 NOV 2012													
CHECKED: E BURGON	10 NOV 2012													
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				<table><tr><td>SCALE 1 : 4</td><td>ONE SIZE</td><td>ONE IN</td><td>REV</td></tr><tr><td>SHEET 1 OF 1</td><td>A1</td><td>95917</td><td>1</td></tr></table>			SCALE 1 : 4	ONE SIZE	ONE IN	REV	SHEET 1 OF 1	A1	95917	1
SCALE 1 : 4	ONE SIZE	ONE IN	REV											
SHEET 1 OF 1	A1	95917	1											

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

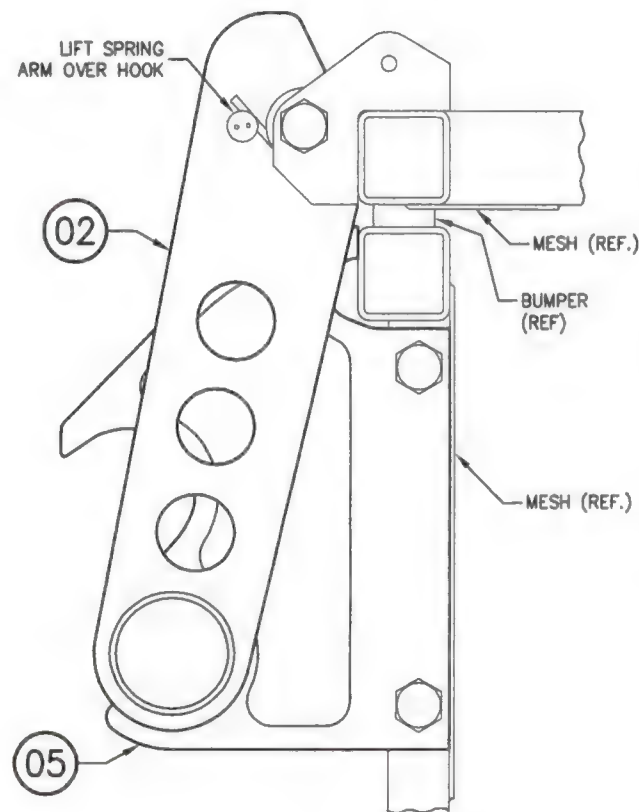


01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE		MIL-PRF-81322F
4	AN3-11A		BOLT		
2	AN3-12A		BOLT		
10	NAS1149F0363P		WASHER		
6	MS21044N3		NUT		
2	84267-01	05	BRACKET		
2	36275-01	04	BUSHING		
2	36278-01	03	SPRING (1 LH, 1 RH)		
1	84261-01	02	HANDLE BAR ASSEMBLY		
	84255-01	01	HANDLE INSTALLATION		
01	PART NO.	ITEM	DESCRIPTION		MATERIAL
QTY.	LIST OF MATERIALS				

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGON	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.

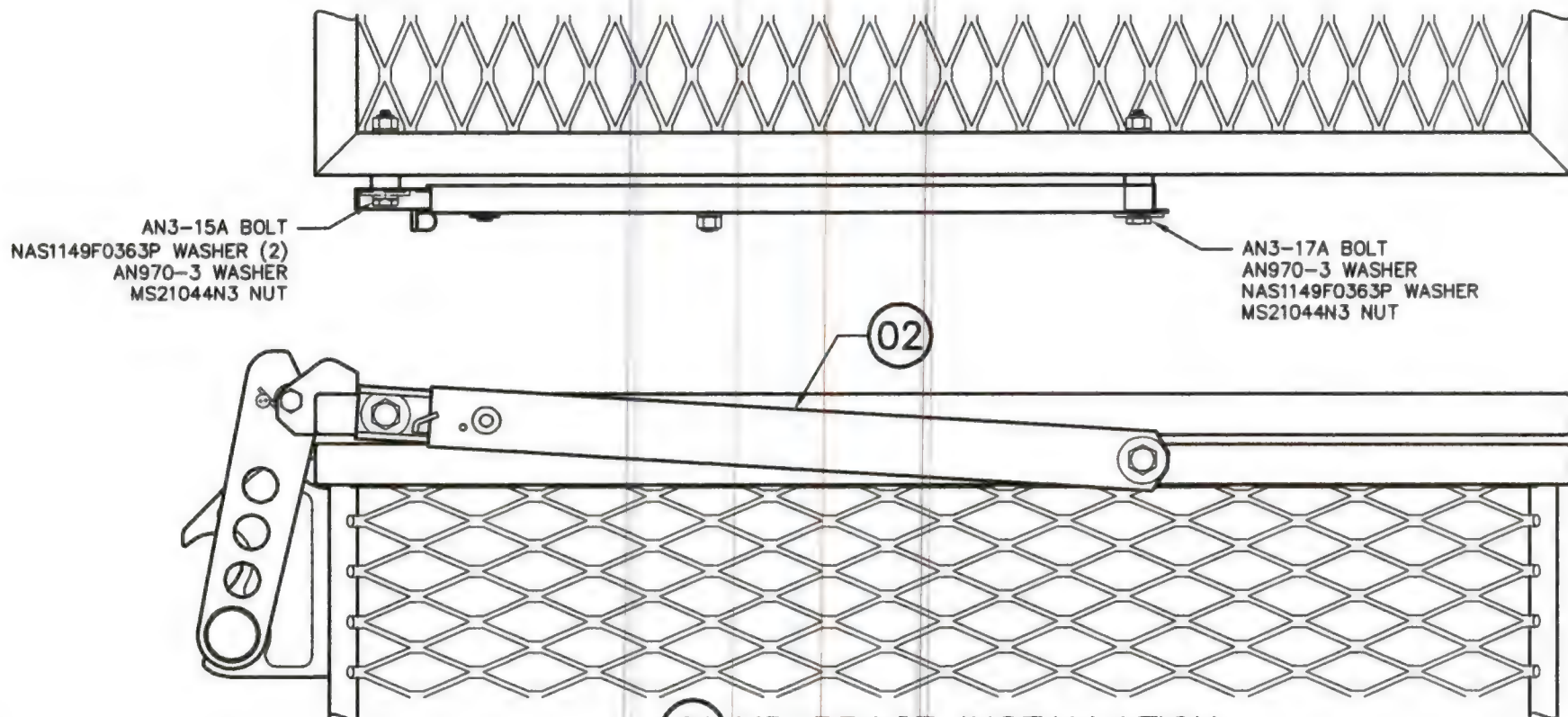
9688A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.488.3576 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 LID BRACE INSTALLATION

NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

 AERO DESIGN LTD. 9886A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.488.2378 www.aerodesign.ca		HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION	
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

Work Order: 2017-160

Material Tracking Sheet

1 of 2

Bell 429 - Post 81

Date Opened: 27 SEPT 2017

Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		<u>95950-01-01</u>	<u>Cargo Basket Assembly</u>	<u>(-01 RH, -02 LH)</u>	<u>S/W 95911-06 2015-03 CB</u>
Step 1				<i>Lid Assembly</i>		
Step 1.a.	. 1		95912-01-XX	Basket Lid Assembly		2017-140
	. . 4		49205-14	Bumper	Argus Industries Bumper	See PDS
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	17081 CB
	. . 1		95917-XX	Lid Checker Plate	3003 Aluminum Tread Plate, 0.063"	17081
	. . A/R		CR3213-4-02	Cherry Rivet		16053
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		95951-01-XX	Basket Body Assembly		2017-140-01
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	. . 8		NAS1149F0663P	Washer		See PDS
	. . 1		95965-01	Forward Sheet		2016-148
	. . 1		95916-03	Filler Sheet		2016-148
	. . 1		95927-01-XX	Placard	0.050 Sheet, 6061-T6 Aluminum	2015-03
	. . A/R		CR3213-4-02	Cherry Rivet	forward sheet and placard	16053
	. . A/R		CR3213-5-02	" "	filler sheet	17070
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	17017
	. 8		CR3523-5-02	Cherry Rivet	horizontal	16063
	. A/R		CR3213-5-02	Cherry Rivet	horizontal	17070
			CR3523-5-03 CR3213-5-03	" "	vertical vertical	15031 17039
Step 4	. 1		84255-01	Handle Installation		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	. . 4		AN3-11A	Bolt		See PDS
	. . 8		NAS1149F0363P	Washer		See PDS
	. . 4		MS21044N3	Nut		See PDS

Work Order: 2017-160Material Tracking Sheet
Bell 429 - Post 81
Basket Assembly

2 of 2

Date Opened: 27 SEPT 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	POWO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-118
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-119
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
Step 6				Inspection	None	



WO#

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: XL Basket Handle No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 84261-Rev 2 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-118

Remaining Tasks to be Performed: Install

Signature: [Signature]

Date: July 19/2017 Lic. No. / SCA AD-05



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Tread Plate

Aircraft: All Model: N/A

Description: Lid Walkway Checker Plate

Supplier: Ryerson

Color: Aluminum

WO#: N/A

PO# 17081



Aero Design Ltd.

R/H

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Basket Body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 95951-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-140-01

Remaining Tasks to be Performed: Clean up, Inspect,
powder coat. ✓ ✓ ✓

Signature: Dwight

Date: Aug 24/2017 Lic. No. / SCA 73-04

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

powder coat 17085



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Lid R/H No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 95912-01-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-140

Remaining Tasks to be Performed: Clean up, inspect,
powder coat. ✓ ✓ ✓

Signature: [Signature]

Date: Aug 18/2017 Lic. No. / SCA 7304
05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder coat 17085

CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-160

Date Open: 27 Sept 2017

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

		Basket			Lid	Lid	Handle		
✓	Basket Type	Ass'y	Placard	Mat'l	Walk	Prop	Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	80210	80227	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	80310	80327	Mat'l					Mat'l
	Long	81110	81127	Mat'l					Mat'l
Bell 206L/407 – Right side only									
	Low Standard	69810	69827	Mat'l	70405	84240	84255	84261	Mat'l
	Low Wide	94510	94527	Mat'l					Mat'l
	Low Ski	94610	94627	Mat'l					Mat'l
	High Ski	76610	76625	Mat'l					Mat'l
Bell Medium – left or right									
	Standard	75110	75127	Mat'l	70405	84240	84255	84261	Mat'l
	Extra Large (ski)	95510	95527	Mat'l					Mat'l
	Mega	100610	100627	Mat'l					Mat'l
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	Mat'l	70405	84240	84255	84261	Mat'l
✓	Standard – Post S/N 71	95950	95927	Mat'l					Mat'l
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	76410	76427	Mat'l					Mat'l
	Long	78410	78427	Mat'l					Mat'l
	Ski	94010	94027	Mat'l					Mat'l
Robinson R44 – left or right									
	Standard	90610	90627	Mat'l	70405	84240	84255	84261	Mat'l
MD600									
	Standard	82810	82827	Mat'l	70405	84240	84255	84261	Mat'l

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).

CMB
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73-04
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1. Lid Assembly

a. Install lid bumpers on bottom.

- i. Drill $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

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73-04
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- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
 - i. Locate sheet on basket.
 - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
 - i. Locate sheet on basket. Ensure sufficient clamps are in place.
 - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 766, 784 – 90"
 - 5. 940, 946, 959 – 95"
 - 6. 1006 – 107"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

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AD
73-04
01

- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in.
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

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5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

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6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

CMB
PD
73-04
01

7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

J